

Work Order ID 60501

Tuesday, July 13, 2010 10:04:09 AM

Page 1

Item ID: D1049

Accept

Revision ID:

Item Name: Saddle

Start Date: 7/13/2010 Start Qty: 20.00

Required Date: 7/20/2010 Req'd Qty: 20.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date: 10-7-13

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D1049

Rev A

100



SHEAR

0.00

Shear

Memo

0.00

Shear

Cut Blanks: 2.000" long

mf
10/07/23

20 0

110



HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per folio FA217 & Dwg D1049
2-Debur

mf
10/07/27

20 0

120



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

mf
10/07/27

20 0

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

amt 10/07/27

20

0

140

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

= 7 MJ 10/07/26

x20

0

150

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

Powdercoat

Memo

0.00

Powder Coating

START TIME: 11:40
OVEN TEMPERATURE: 320°
FINISH TIME: 12:10

20 10-7-28.

W/O:		WORK ORDER CHANGES						
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Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10/07/25

20

0

170

Identify as per dwg & Stock Location: Stu2

0.00



Packaging

Memo

0.00

Packaging

10/07/28 (20)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/07/29

u 10/07/28

W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Tuesday, July 13, 2010 10:04:13 AM

Page 1

Work Order ID: 60501



Parent Item: D1049

Parent Item Name: Saddle

Start Date: 7/13/2010

Required Date: 7/20/2010

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP RevC 02.04.10 Re-format NG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.750X00.25 0		Purchased	No			100	f	20.0000	0.1666	3.507368			



6061-T6 Bar .750 x .250



Location

Loc Qty

Loc Code

MAT028

20

114968

20

3.500

mJ
10/07/23

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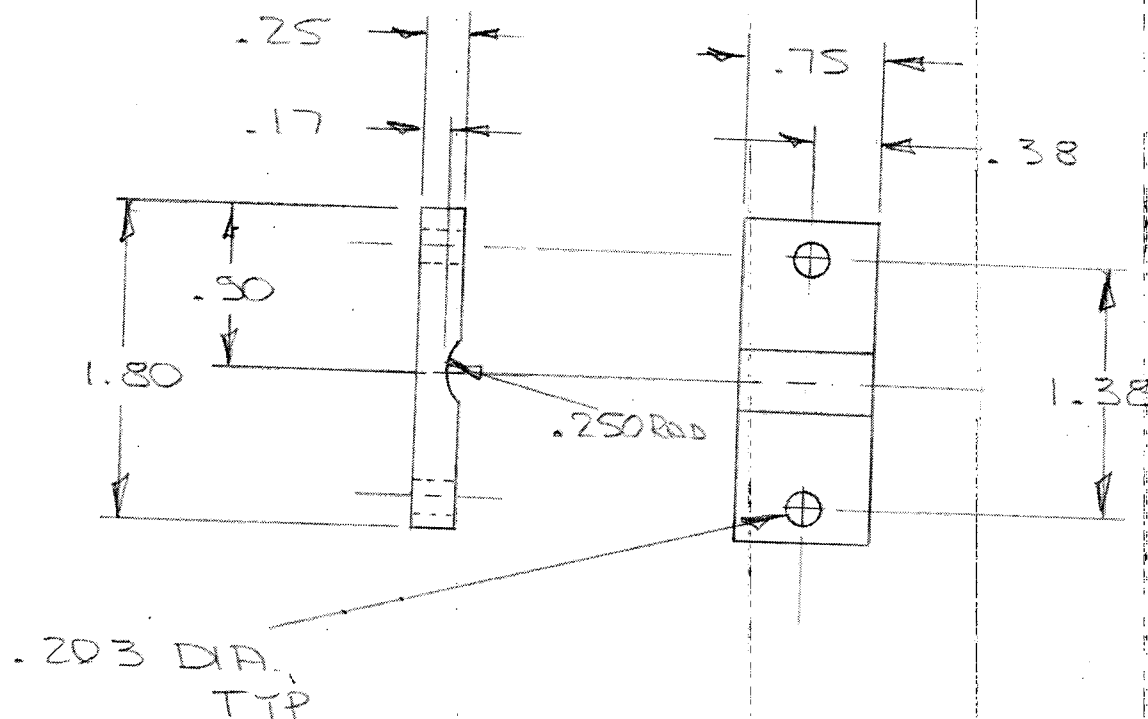
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RELEASED
87/09/02 B.W.



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. U0501

MATERIAL: 5052-H32

FINISH: POWDER COAT



REVISION	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPD OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.		RIVET CODE SHALL BE PER NAS 523		PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC. VENDOR
DRAWN			BASIC CODE	DIA. DASH NO. IN-HEAD NEAR SIDE P-HEAD FAR SIDE	CONTRACT NO.				
APPROVED			D-DRAWL DIGIT-NO OF SHEETS C-COUNTERSINK	LENGTH DASH NO. W-SPOTHELD	DRAWN	DATE	DART DART AERO ACCESSORIES INC. VANCOUVER CANADA		
DESCRIPTION OF CHANGE	REQUIREMENTS — UNLESS OTHERWISE SPECIFIED GENERAL 1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS 194 3. ROUNDED SHARP EDGES .015 MAX 4. THREADS PER INCH - S - 2742 5. HOLES PER AND 10287 LIMITS 1. TOLERANCES — JDX & .000 2. ANGLES — XXX & .010 3. PARALLELISM — W 4. ECCENTRICITY — .0025 5. SYMMETRY ABOUT ALL M/C CENTRE LINES .005		BASIC CODES BJ-M520470AD BB-M520426AD		DESIGN	1982	TITLE SADDLE		
REPORT ALL DISCREPANCIES — DO NOT SCALE					STRESS		CODE	DWG NO. D1049	REV
					CHECKED		SCALE	SHT	OF
					CLIENT				

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